

Tuesday, 4/18/2006 9:59:40 AM Kim Johnston

Process Sheet

SPLIT

PT				
Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG	
Job Number	: 26647 3			
Estimate Number	: 10337			
P.O. Number	. NIA	Part Number	: D28073	
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D2807 REV C	
Prsht Rev.	: NC	Project Number	: N/A	
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: C	
Previous Run	: 26625	Material	: NIA	
The state of the s	: SEEIN COMMENT BELOW!	Due Date	: 4/30/2006 Qty: (60)	Um: Each
Written By	200 00 19 19		7	4
Checked & Approv	the state of the s			
Comment	: Est A 05.66.02 New Issue KJ/JLM			
Additional Product	¥1			
Job Number:				
Seq. #:	Machine Or Operation:	Description:		
1.0	M303R0750 303 Roun	d Bar .75*	NO. CONT. CO.	
Comme	ent: Qty.: 0.1094 f(s)/Unit Total: 6.5646 f(s)	110000	/	
John	Material: 303 Round Bar Ø0.750"	110080	6	
		Potob	- 1	
	(M303R0.750)	Batch:	PO 06/05/26	
			1 090-120	
2.0	HARDINGE HARDING	SE CNC LATHE SMALL	, 090920	
2.0	HARDINGE HARDING	SE CNC LATHE SMALL		
2.0	HARDINGE HARDING	SE CNC LATHE SMALL		
		SE CNC LATHE SMALL		
	ent: HARDINGE			
	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev			60
Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr	:_ C _	MS OGOSÍA7 4	60
	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr		MS OGOSÍA7 4	60
Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr	:_ C _	MS OGOSÍA7 4	60
Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT	:_ C _	MS OGOSÍZA 4	60
Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr	:_ C _	MS OGOSÍA7 4	60
Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE	:_ C _	MS OGOSIZZ 4	60
3.0	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE	PARTS AS THEY COME	MS OGOSIZZ 4	60
3.0	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE	PARTS AS THEY COME	MS OGOSIZZ 4	60
3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN	PARTS AS THEY COME	MS OGOSIZZ 4	60
3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN	PARTS AS THEY COME	MS OGIOSIZZ 4 E OFF MACHINE MS OGIOSIZZ 4 G#1	60
3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg	PARTS AS THEY COME C VERTICAL MACHINING	MS OGIOSIZZ 4 E OFF MACHINE MS OGIOSIZZ 4 G#1	60
3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg	PARTS AS THEY COME	MS OGIOSIZZ 4 E OFF MACHINE MS OGIOSIZZ 4 G#1	60
3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg	PARTS AS THEY COME C VERTICAL MACHINING	MS OGIOSIZZ 4 E OFF MACHINE MS OGIOSIZZ 4 G#1	60
3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Fo	PARTS AS THEY COME C VERTICAL MACHINING Rev:	MS OGOSIZA 4 EOFF MACHINE MS OGIOSIZA 4 G#1 A Machined Manually 06/06/13	60
3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Fo	PARTS AS THEY COME C VERTICAL MACHINING	MS OGOSIZA 4 EOFF MACHINE MS OGIOSIZA 4 G#1 A Machined Manually 06/06/13	60
Comme 3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Fo	PARTS AS THEY COME C VERTICAL MACHINING Rev:	MS OGOSIZA 4 EOFF MACHINE MS OGIOSIZA 4 G#1 A Machined Manually 06/06/13	60
Comme 3.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Fo	PARTS AS THEY COME C VERTICAL MACHINING Rev:	MS OGOSIZA 4 EOFF MACHINE MS OGIOSIZA 4 G#1 A Machined Manually 06/06/13	60
Comme 4.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Fo 2-Deburr QC2 INSPECT	PARTS AS THEY COME C VERTICAL MACHINING Rev:	MS OGOSIZA 4 EOFF MACHINE MS OGIOSIZA 4 G#1 A Machined Manually 06/06/13	4
Comme 4.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Fo	PARTS AS THEY COME C VERTICAL MACHINING Rev:	MS OGOSIZA 4 EOFF MACHINE MS OGIOSIZA 4 G#1 A Machined Manually 06/06/13	60
Comme 4.0 Comme	ent: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev 2-Deburr QC2 INSPECT ent: INSPECT PARTS AS THEY COME OFF MACHINE HAAS1 HAAS CN ent: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Fo 2-Deburr QC2 INSPECT	PARTS AS THEY COME C VERTICAL MACHINING Rev:	MS OGOSIZA 4 EOFF MACHINE MS OGIOSIZA 4 G#1 A Machined Manually 06/06/13	4

Dart Aerospace Ltd

W/O:			WORK ORDER CH	HANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Yes	No) DQ	A: 5	D Date:	6/06/14

QA: N/C Closed: ____ Date: ____

NCR:	: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Verification	A	Assessed
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Tuesday, 4/18/2006 9:58:40 AM **Process Sheet** Kim Johnston Drawing Name: LUG Customer: CU-DAR001 Dart Helicopters Services Part Number: D28073 Job Number: 26647 Job Number: Description: Machine Or Operation: Seq. #: SECOND CHECK QC8 6.0 86 Comment: SECOND CHECK PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 6. A 4 06:06:13 DOCUMENT CONTROL 8.0 D 0x0/06/14 Comment: DOCUMENT CONTROL Inspection Level 21

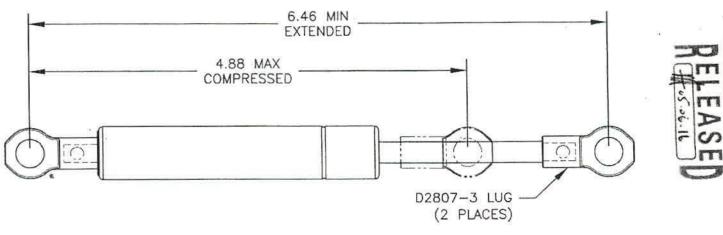
Job Completion

Dart Aerospace Ltd

DailAc	rospace L	itu								
W/O:			WO	RK ORDER CHANGE	S					
DATE	STEP	PR	OCEDURE CHAP	NGE	By Date Qty Ch			Approval Chief Eng / Prod Mgr	Approval Chief Eng / Prod Mgr Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _		
					QA: N/	C Close	d:	_ Date: _		
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector	

NOTE: Date & initial all entries





0.24 TO CRIMP (TYP) CRIMP 0.015-0.025" DEEP WITH Ø0.375 TOOL AT 2000psi (REF), TYP TWO SIDES PER LUG

D2807	GAS	SPRING

SIHT

DOCUMENT

AEROSPACE INDITION THAT IT IS NO PERMISSION FROM

FOR.

ANY PURPOSE OR COPIED

1) SPEGIFICATION: SS GAS SPRING

ACCEPTABLE LOAD RANGE IS 25 Ib MIN TO 45 Ib MAX

M5x0.8 THREADS

M5x0.8 THREADED ENDS, ACCEPTABLE TO TRIM END

COMPRESSED DIMENSION (TYP)

UP TO 0.050 TO MEET

ArvinMeritor Motion Control Systems, Leicester, UK

P/N: SXF6S6050080S6L-115N

(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

AMENDICE ALLED COMENSIONS ARE IN INCHES

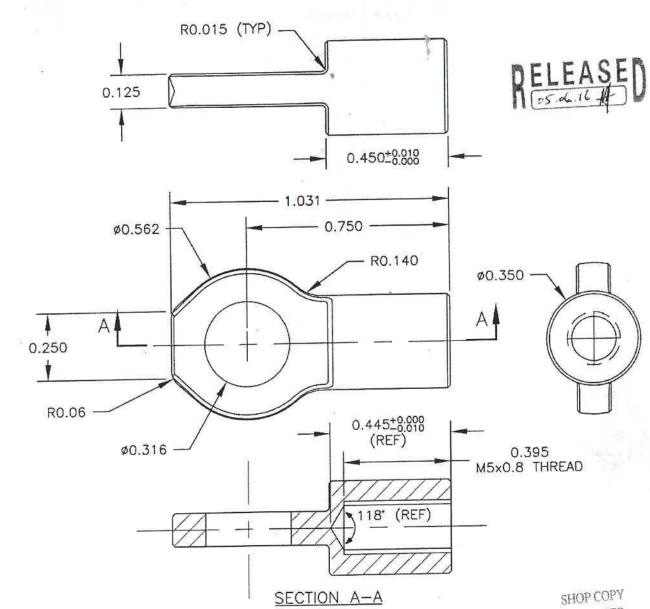
4) TOTERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

			1			
0	В	Þ	05.05.25	DATE	CHECKED	CP CP
05.05.25	05.03.16	00.11.03			APPROVED	DRAWN BY
CHANGE SPRING TO SS, ADD -3 LUG	05.03.16 ADD FINISH	NEW ISSUE	GAS SPRING	THE	D2807 SHE	DART AEROSPACE LTD
LUG				SC	SHEET 1 OF	1

OF 2



DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	2. 1.07 No. 3, 141	GAS SPRING	SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

TAEROS	PACE LTD				Work Order:	26647
escription: C	sur spring.		Amount of the	100	Part Number:	_103801_
Inspection Dwg:	2807 Rev:	C		- All Madel		Page 1 of 1
	FIRST	ARTICLE IN		ON CHE		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.031	±.010	1.035	~		6	
250 "	±.010	-250	~			
R.140	W	.140	~			
¢ 350	W.	.351	~			
.395	ч	:392	~			
MSX. B. Hread		MSX.8				
Ø. 562	7	\$.560				
1125	±.010	1125				
,316	+.006	1317				
.750	±.010	,750				
.450	+.010	,453				
	9 * 3					

Measu	ired by:	MS/100	Audited by:	Sp / Int	Prototype Approval:	
	Date:	00105/27	Date:	06/05/29	Date:	
		06/06/12			1	
Rev	Date	Change			Revised b	y Approved
А		New Issue			KJ/RF	